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in order

D4776-1

Job Sheet 189173



Part No: D4776-1

Job Qty: 50 pcs

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 2/16/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG D4776 REV.E IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	50 pcs		2/16/19	0.54	26.60	Doosan - 1		<i>19/02/08</i>
105	QC 2	50 pcs		2/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		<i>19/02/08</i>
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		

111 QC 8	50 pcs	2/16/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	RT 2019-02-10
112 Handfinish - 1-1 Chemical-B4B	50 pcs	2/16/19	0.00 1.43	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR 19/2/17
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	

				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
113 QC 7	50 pcs	2/16/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	BR 19-02-12
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 38	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
115 Powdercoat - 1 White Gl(A)- B4B	50 pcs	2/16/19	0.00 0.58	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BR 19-02-12
				Powdercoat - 4 - B4B	
116 QC 3	50 pcs	2/16/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	DAS FEB 21 2019 68
				QC 3 - 9	9-89
130 Packaging 3-1 - Stock - B4B	50 pcs	2/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	5114 21 FEB 22 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	50 pcs	2/16/19	0.00 0.00	QC 21 - SA - 21 21 FEB 22 2019
					QC 21 - SA - 70 21 FEB 22 2019
Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB167 Rev: _____ & Dwg D4776 Rev: _____ 2 -Deburr per dwg D4776 Descriptions: 105 - (QC2- Inspect parts off machine FAI/FAIB) 111 - (QC8- Inspect parts - second check) 112 - (Chemical Conversion Coat per QSI005 4.1)					

113 - (QC7-Inspect Chemical Conversion Coat)

115 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) MASK .403 ROUND SECTION AS PER DWG START TIME:

10:30 OVEN TEMPERATURE: 320° FINISH TIME: 11:00 M138997

116 - (QC3- Inspect Part Finish)

130 - (Identify as per dwg & Stock Location:)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	14.5000 ft (.29 ea)	100-Doosan - 1	5150603
		34/ea		5052637

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R1.500	15	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850	.8805	
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428	.439	
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350	.381	
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615	.6235	
5	Basket Strut Clevis	1.750Inches ± 0.030	1.780 1.720	1.75	
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470	3.5	
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	45 Angle	
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060 0.000	.028	
9	Basket Strut Clevis	0.060Inches ± 0.030	0.090 0.030	R/16 Radius	
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	.1975 Diameter	
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	.2625 Diameter	
12	Basket Strut Clevis	0.410Inches ± 0.030	0.440 0.380	.408 Radius	
13	Basket Strut Clevis	1.130Inches ± 0.030	1.160 1.100	1.13	
14	Basket Strut Clevis	0.188Inches ± 0.010	0.198 0.178	.186	
15	Basket Strut Clevis	0.190Inches ± 0.030	0.220 0.160	.186	
16	Basket Strut Clevis	0.500Inches ± 0.030	0.530 0.470	.503	
17	Basket Strut Clevis	0.750Inches ± 0.010	0.760 0.740	.749	
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	.400 Diameter	
19	Basket Strut Clevis	0.130Inches ± 0.030	0.160 0.100	R/8 Radius	
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750	.754	
21	Basket Strut Clevis	0.160Inches ± 0.030	0.190 0.130	.162	
22	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	45 Angle	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

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Container No: S152159



Part: D4776-1

Job No: 189173

Serial No/Batch: S152159

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/08/19